

Date: Tuesday, 5/23/2006 8:13:01 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSBOLT SPACER
Job Number : 27167	
Estimate Number : 10993	
P.O. Number : N/A	Part Number : D2579
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D2579 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 25977	Material : N/A
Written By : <u> </u>	Due Date : 6/15/2006
Checked & Approved By : <u> </u>	Qty: <u>505</u> Um: Each
Comment : Est E 02.06.17 Now turned on Cobra NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.3762 f(s)/Unit Total : 188.1075 f(s)
6061-T6 Tube .500 x.058W
Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)
0.500 Dia x 0.058 Wall Batch _____

M100423 16'
M101119

En / MS 06/06/08 SOS

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
Machine as per Folio FA245

En / MS 06/06/08 SOS

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En / MS 06/06/08 SOS

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.06.08 SOS

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

AR 06/06/09 (505)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
					10		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:13:01 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 27167

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/06/09 505

Job Completion



in 06-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

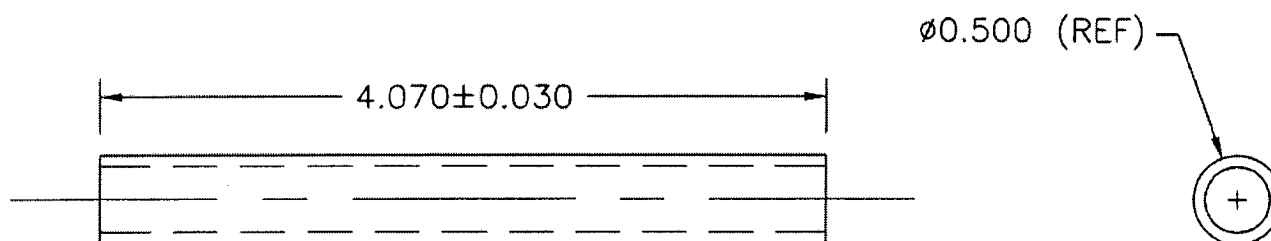
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN DA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DA	APPROVED LE	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	

RELEASED
99.05.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27167